

Work Order ID: 82726

82726

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Thursday, April 05, 2012 12:58:39 PM

Item ID: D3504-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crossbolt Spacer

Start Date: 4/5/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date: 12-04-5 Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3504	Rev C

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

0.00

1-TURN AS PER FOLIO FA643 & DWG D3504,
FOLIO REV: _____
DWG REV: _____
2-DEBURR AS REQUIRED

Manual

12-4-12

18

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

12-4-12

18

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

12-4-12

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82726

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82726

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Item ID: D3504-3 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crossbolt Spacer
Start Date: 4/5/2012 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 4/13/2012 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00				18	0	3212/04/13	
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/17
12-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Thursday, April 05, 2012 12:58:43 PM

Work Order ID: 82726

82726

Parent Item: D3504-3

D3504-3

Parent Item Name: Crossbolt Spacer

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Rev C dwg 07-12-06 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.049		Purchased				100	f	54.0000	0.283	4.766316			

M6061T6T0 375W 049

**

6061-T6 RD Tube .375 x.049W

Location

Loc Qty

Loc Code

MAT014

54

116720

12

119160

42

54 ~~54~~ 12-4-12

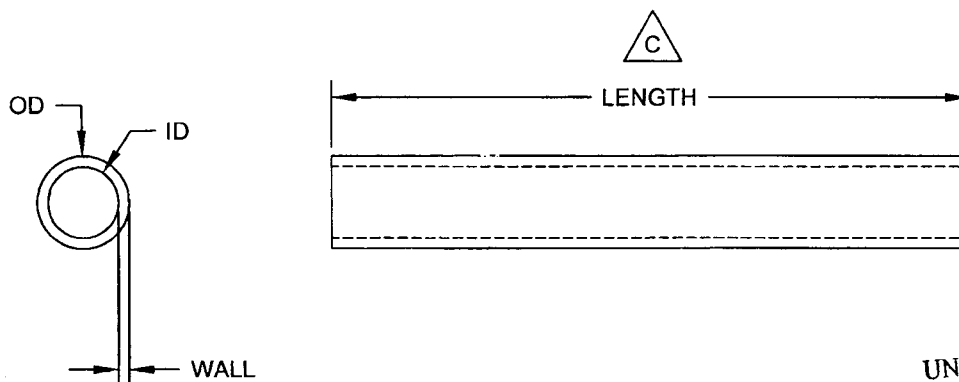
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82726

D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

1012-04-5

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)



D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
07.11.16

C	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3504	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	CROSS BOLT SPACER	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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